

Date: Wednesday, 6/28/2006 4:19:13 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHORT STEP INSTALLATION KIT
 Job Number : 27760
 Estimate Number : 10542
 P.O. Number : N/A Part Number : K591113
 This Issue : 6/28/2006 S.O. No. : N/A Drawing Number : D350-591 REV F PG17
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : F
 Previous Run : 27308 Material : N/A
 Due Date : 8/20/2006 Qty: 12 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature]
 Comment : Est: C 04.11.09 Reformat KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2171 Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Clamp

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-----------|
| 2 | D2171 | Clamp | B 27244 ✓ |

2.0 D2182B Neoprene Cushion-.750 bl



Comment: Qty.: 0.5833 f(s)/Unit Total : 6.9996 f(s)

Neoprene Cushion-.750 bl

Pick:

| Qty | Part Number | Description | Batch |
|--------------|-------------|-------------|-----------|
| 7"(2 x 3.5") | D2182B | Cushion | B 24870 ✓ |

3.0 D2274 Radius Block



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Radius Block

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|--------------|-----------|
| 4 | D2274 | Radius Block | B 26500 ✓ |

8 x B27581 AP 8/8

4.0 D23623 Step Support Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Step Support Bracket

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-----------------|---------------|
| 1 | D2362-3 | Support Bracket | B 27309 (4) ✓ |

B 27765 x 8 ✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:19:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP INSTALLATION KIT

Job Number: 27760

Part Number: K591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 7.2000 f(s)

Abrasion Strip

Pick:

Qty

Part Number

Description

Batch

7.2"

D2856-400

Abrasion Strip

B25656-7

D2856-600 pulled to make
400
A66/08/02

6.0

AN337A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3-37A

Bolt

M13719 ✓

7.0

AN420A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

AN4-20A

Bolt

M14855 ✓

8.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

1

AN4-22A

Bolt

M18822 ✓

9.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

4

AN960JD10

Washer

M100743 ✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP INSTALLATION KIT

Job Number: 27760

Part Number: K591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 72.0000 Each(s)

Washer

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|------------|
| 6 | AN960JD416 | Washer | M 101369 ✓ |

11.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|------------|
| 2 | MS21042L3 | Nut | m 100393 ✓ |

12.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nut

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-----------|
| 5 | MS21042L4 | Nut | m 19085 ✓ |

PB 06/08/08

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

AL 06/08/08

(12)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PB

06/08/22

C2

(12)

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.08.22

Job Completion



C2 06/08/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

5. PARTS LIST

| Qty -111A | Qty -113 | Qty -115 | Qty -117A | Qty -119 | Qty -133 | Part Number | Description |
|--------------|-------------|-------------|--------------|-------------|-------------|---------------|---|
| X | | | | | | D350-591-111A | <i>Heli-Access-Step</i> ™, Long Step – High Skid |
| | X | | | | | D350-591-113 | <i>Heli-Access-Step</i> ™, Short Step – High Skid |
| | | X | | | | D350-591-115 | <i>Heli-Access-Step</i> ™, Short Step – Low Skid |
| | | | X | | | D350-591-117A | <i>Heli-Access-Step</i> ™, Pre-Flight Step |
| | | | | X | | D350-591-119 | <i>Heli-Access-Step</i> ™, Long Step – Low Skid |
| | | | | | X | D350-591-133 | <i>Heli-Access-Step</i> ™, Aft Maintenance Step |
| | 1 | | | | | D2310 | STEP ASSEMBLY (HIGH-SHORT) |
| 1 | | | | | | D2311 | STEP ASSEMBLY (HIGH-LONG) |
| | | 1 | | | | D2354 | STEP ASSEMBLY (LOW-SHORT) |
| | | | | 1 | | D2355 | STEP ASSEMBLY (LOW-LONG) |
| | | | | | 1 | D2946-041 | STEP ASSEMBLY (MAINTENANCE) |
| 4 | 2 | 2 | 2 | 2 | | D2171 | CLAMP |
| 4 | 2 | 2 | 2 | 2 | | D2182B035 | CUSHION |
| | | | | | 4 | D2230-1 | MOUNTING LUG |
| | | | | | 4 | D2230-3 | MOUNTING LUG |
| 8 | 4 | 4 | 4 | 4 | | D2274 | RADIUS BLOCK |
| | | | 1 | | | D2362-041 | SUPPORT BRACKET |
| 2 | 1 | | | 1 | | D2362-3 | SUPPORT BRACKET |
| | | 1 | | | | D2362-5 | SUPPORT BRACKET |
| 2 | 1 | 1 | 1 | 1 | 2 | D2856-400-720 | ABRASION STRIP |
| | | | | | 1 | D2945 | MOUNTING PLATE |
| 2 | 2 | 2 | | 2 | | AN3-37A | BOLT |
| | | | | | 2 | AN4-7A | BOLT |
| | | | | | 4 | AN4-11A | BOLT |
| | | | | | 8 | AN4-14A | BOLT |
| 8 | 4 | 4 | 4 | 4 | | AN4-20A | BOLT |
| 1 | 1 | 1 | | 1 | | AN4-22A | BOLT |
| 4 | 4 | 4 | | 4 | | AN960JD10 | WASHER |
| 10 | 6 | 6 | 4 | 6 | 14 | AN960JD416 | WASHER |
| 2 | 2 | 2 | | 2 | | MS21042L3 | NUT |
| 9 | 5 | 5 | 4 | 5 | 14 | MS21042L4 | NUT |

| Qty -121 | Qty -122 | Qty -123 | Qty -124 | Part Number | Description |
|-------------|-------------|-------------|-------------|---------------|---|
| X | | | | D350-591-121 | <i>Heli-Access-Step</i> ™, Short Step – High Skid, LH |
| | X | | | D350-591-122 | <i>Heli-Access-Step</i> ™, Short Step – High Skid, RH |
| | | X | | D350-591-123 | <i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH |
| | | | X | D350-591-124 | <i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH |
| 1 | | | | D2351-041 | STEP ASSEMBLY (HIGH-SHORT, LH) |
| | 1 | | | D2351-042 | STEP ASSEMBLY (HIGH-SHORT, RH) |
| | | 1 | | D2356-041 | STEP ASSEMBLY (LOW-SHORT, LH) |
| | | | 1 | D2356-042 | STEP ASSEMBLY (LOW-SHORT, RH) |
| 1 | 1 | 1 | 1 | D2230-1 | MOUNTING LUG |
| 1 | 1 | 1 | 1 | D2230-3 | MOUNTING LUG |
| 1 | 1 | 1 | 1 | D2856-400-720 | ABRASION STRIP |
| 2 | 2 | 2 | 2 | AN3-37A | BOLT |
| 3 | 3 | 3 | 3 | AN4-13A | BOLT |
| 4 | 4 | 4 | 4 | AN960JD10 | WASHER |
| 6 | 6 | 6 | 6 | AN960JD416 | WASHER |
| 2 | 2 | 2 | 2 | MS21042L3 | NUT |
| 3 | 3 | 3 | 3 | MS21042L4 | NUT |

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